

Work Order ID 152301

Friday, October 21, 2016 3:03:53 PM

152301

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Item ID: D2278 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg
 Start Date: 12/7/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/12/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-29** Date: **OCT 27 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2278	Rev F								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.30
 FLOW CNC Waterjet 1-Cut as per Dwg D2278 Dwg Rev: **F** Prog Rev: **F** 2-
 Deburr if necessary

(20) **20** 10/11/16

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.03
 Quality Control

(20) **20** 10/11/16

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.07
 Quality Control

(20) **DAS 38 9-29**
NOV 07 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.07				<u>(x20)</u>	<u>0</u>		2-16/11/08 BEB.
140	QC7-Inspect Chemical Conversion Coat	0.00							
140 QC Quality Control	Memo	0.03				<u>(20)</u>			DAS 38 9-89 NOV 08 2016
150	Identify as per dwg & Stock Location: _____	0.00							
150 Packaging Packaging	Memo LOCATION : GA	0.03				<u>20</u>			NOV 8 7 2016 DAS 6 9-89

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160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.33							
Quality Control									

16/11/9 JF

16-11-09

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D2278

Required Qty: 20.00

Comments:	IPP Rev:A	New Issue	05-11-07	JLM
	IPP Rev:B	Now 6061-T6	06-06-23	JLM
	IPP Rev C	New flat pattern	08.01.11	EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	195.6700	0.9815	20.66316			

M6061T6S 080

6061-T6 .080 Sheet

(21)

on 11/11/06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	195.67	
134217	9.1	
m132772	4.3	
m133587	7.7	
m133828	2.6	
m134551	7	
m134830	21.9	
m135147	21.2	
m135559	31.37	18.5
m135861	90.5	2.5

DQA: _____ Date: _____

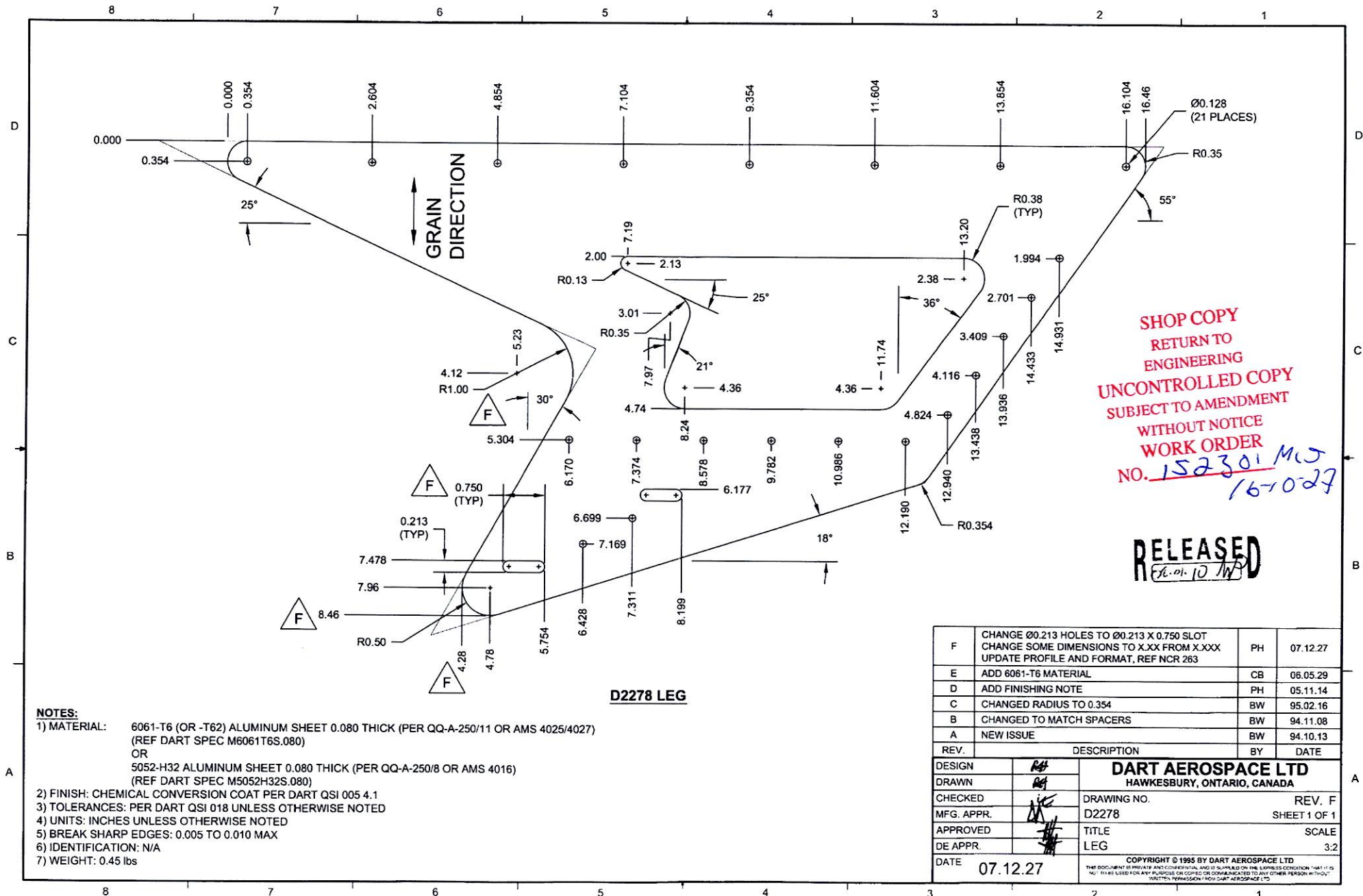
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Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								



F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RF</i>		
CHECKED	<i>RF</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>RF</i>	D2278	SHEET 1 OF 1
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	LEG	3:2
DATE	07.12.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	